



APF0038/48 Stock Feeder

Owner's Manual



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M-4016 04/2008
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Warranty

Oliver makes every effort possible to assure that its equipment meets the highest possible standards of quality and durability. All products sold by Oliver are warranted to the original customer to be free from defects for a period of 2 (two) years on all parts, excluding electronics and motors, which are warranted for 1 year. Oliver's obligation under this warranty shall be exclusively limited to repairing or replacing (at Oliver's option) products which are determined by Oliver to be defective upon delivery F.O.B. (return freight paid by customer) to Oliver, and on inspection by Oliver. This warranty does not apply to defects due, directly or indirectly, to misuse, abuse, negligence, accidents, unauthorized repairs, alterations, lack of maintenance, acts of nature, or items that would normally be consumed or require replacement due to normal wear. In no event shall Oliver be liable for death, personal or property injury, or damages arising from the use of its products.

Warning

Read this manual thoroughly before operating the machine. Oliver Machinery disclaims any liability for machines that have been altered or abused. Oliver Machinery reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

For More Information

Oliver Machinery is always adding new Industrial Woodworking products to the line. For complete, up-to-date product information, check with your local Oliver Machinery distributor, or visit www.olivermachinery.net

WARNING

Read this manual completely and observe all warning labels on the machine. Oliver Machinery has made every attempt to provide a safe, reliable, easy-to-use piece of machinery. Safety, however, is ultimately the responsibility of the individual machine operator. As with any piece of machinery, the operator must exercise caution, patience, and common sense to safely run the machine. Before operating this product, become familiar with the safety rules in the following sections.

1. **If you are not properly trained** in the use of a stock feeder do not use until the proper training has been obtained.
2. **Read, understand and follow** the safety instructions found in this manual. Know the limitations and hazards associated with this machine.
3. **Electrical grounding:** Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the National Electrical Code.
4. **Eye safety:** Wear an approved safety shield, goggles, or glasses to protect eyes. Common eyeglasses are only impact-resistant, they are not safety glasses.
5. **Personal protection:** Before operating the machine, remove tie, rings, watch and other jewelry and roll up sleeves above the elbows. Remove all loose outer clothing and confine long hair. Protective type footwear should be used. Where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations, use hearing protective devices. Do not wear gloves.
6. **Guards:** Keep the machine guards in place for every operation for which they can be used. If any guards are removed for maintenance, DO NOT OPERATE the machine until the guards are reinstalled.
7. **Work area:** Keep the floor around the machine clean and free of scrap material, saw dust, oil and other liquids to minimize the danger of tripping or slipping. Be sure the table is free of all scrap, foreign material and tools before starting to use the machine. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Use anti-skid floor strips on the floor area where the operator normally stands and mark off machine work area. Provide adequate work space around the machine.
8. **Material condition:** Do not attempt to feed boards with loose knots or with nails or other foreign material. Do not attempt to feed twisted, warped, bowed stock.
9. **Operator position:** Maintain a balanced stance and keep your body under control at all times.
10. **Before starting:** Before turning on machine, remove all extra equipment such as keys, wrenches, scraps, and cleaning rags away from the machine.
11. **Careless acts:** Give the work you are doing your undivided attention. Looking around, carrying on a conversation, and "horseplay" are careless acts that can result in serious injury.
12. **Disconnect all power sources:** Before performing any service, maintenance, adjustments or when changing blades. A machine under repair should be RED TAGGED to show it should not be used until the maintenance is complete.
13. **Job completion:** If the operator leaves the machine area for any reason, the feeder should be turned "off" before their departure.

14. **Replacement parts:** Use only genuine Oliver Machinery factory authorized replacement parts and accessories; otherwise the warranty and guarantee is null and void.
15. **Misuse:** Do not use this Oliver stock feeder for other than its intended use. If used for other purposes, Oliver disclaims any real or implied warranty and holds itself harmless for any injury or damage which may result from that use.
16. **Drugs, alcohol and medication:** Do not operate this machine while under the influence of drugs, alcohol, or any medication.
17. **Health hazards:** Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead-based paint.
 - Crystalline silica from bricks and cement and other masonry products.
 - Arsenic and chromium from chemically-treated lumber.Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles.

Familiarize yourself with the following safety notices used in this manual:

CAUTION: (This means that if precautions are not heeded, it may result in minor or moderate injury and/or possible machine damage)

WARNING: (This means that if precautions are not heeded, it could result in serious injury or possibly even death).

ADDITIONAL SAFETY RULES FOR STOCK FEEDERS

1. Cutting tools **MUST** be rotating before feeding.
2. **DO NOT** overload the cutting tool by feeding too fast.
3. **ALWAYS KEEP** hands away from rotating parts.
4. **PROVIDE** support for long stock on out feed end of table.
5. **STOP** the feeder before stopping the cutting tool.
6. **DISCONNECT** power before making repairs or adjustment.

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Specifications

Model Number.....	4016
Blade Diameter (In).....	10
Arbor Diameter (In).....	5/8"
Maximum Depth of Cut at 90 Degrees (In).....	3"
Maximum Depth of Cut at 45 Degrees (In).....	2-1/4"
Maximum Cut to the Right of Blade.....	36"
Maximum Cut to the Left of Blade.....	12"
Dust Port Diameter (In).....	4
Table Dimensions w/Extensions (LxW).....	27" x 45-1/4"
Table Height (In).....	36"
Blade Tilt.....	Left
Arbor Speed RPM.....	3,450
Gross Weight (with 36" rails and fence).....	639

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NOTES & EXPLODED VIEWS

LOCATE MOUNTING AND BORING POSITION

A) LOCATE MOUNTING POSITION

1. Elevation and extension of Universal Stands, (SEE **FIG. 1, 2 & 3**, HP shown on motor cover of your feeder.)
2. Refer to **Page 13 FIG. 27, 28, 29** for assistance when mounting the feeder to a shaper, table saw or jointer.
3. For small machine table, an extension bracket (not provided) is recommended. (SEE **FIG. 4.**)

B) LOCATE BORING POSITION

For your boring convenience and accuracy, **A SCALE 1:1 SELF-ADHESIVE DRILLING TEMPLATE** is provided and enclosed in the package. (**FIG. 5**)

1. Remove MOUNTING BASE from packaging. Use it to verify the correct boring position on the drilling template.
2. Prepare 4 sets of bolts & spring washers (not provided).
SIZE OF BOLT
Light Duty (1/4HP) - **M10**
Light-heavy Duty & - **M12**
Heavy Duty ($\geq 1/2$ HP)
LENGTH OF BOLT \geq
Mounting Base (thickness) +
Tabletop (thickness).
3. Avoid table ribs and support underneath the table.

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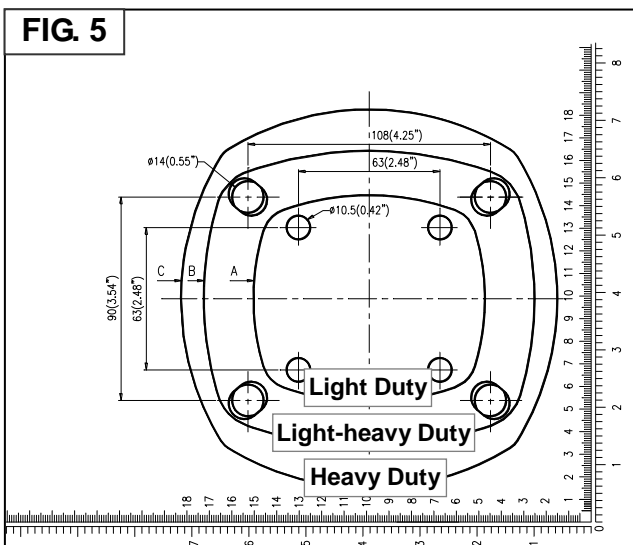
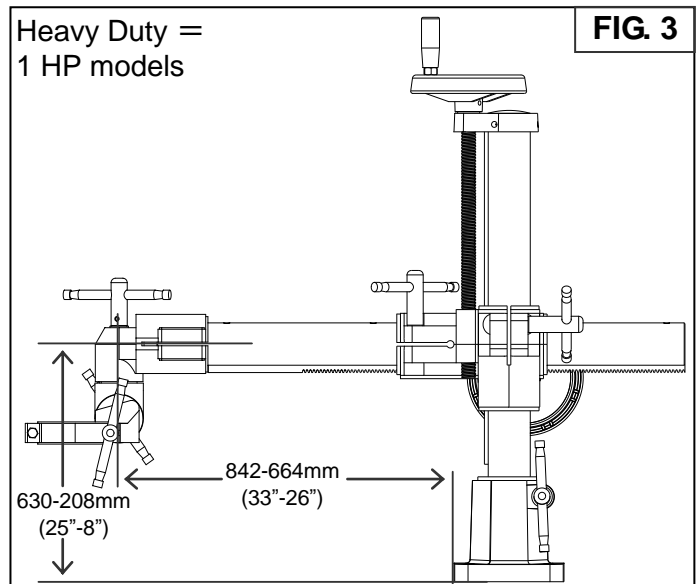
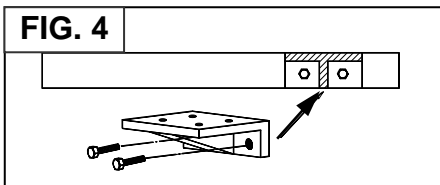
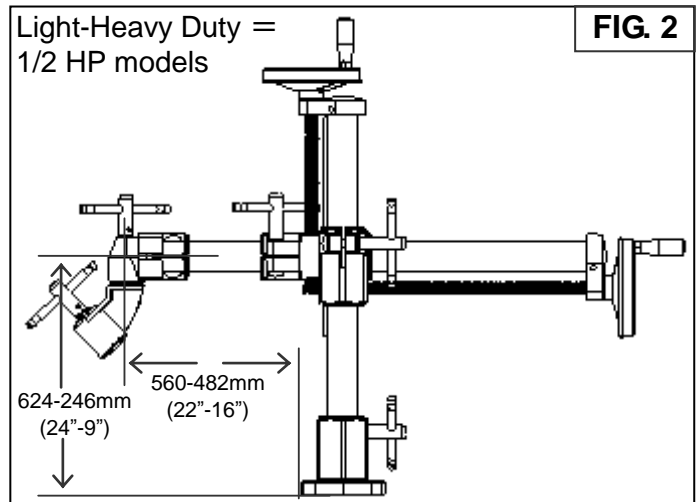
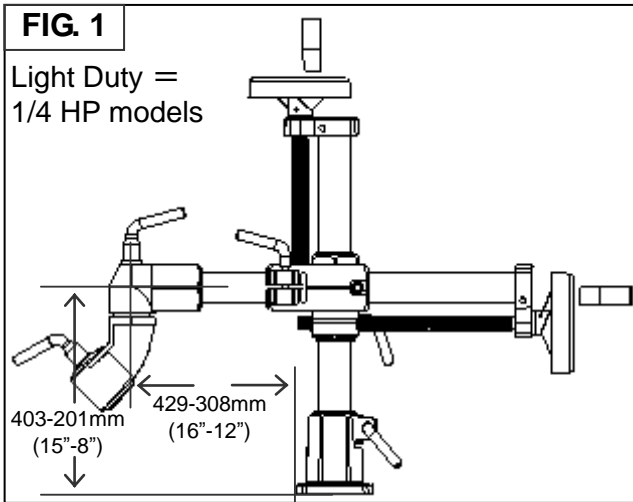
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4. Use **SELF-ADHESIVE DRILLING TEMPLATE**. Tape it

to desire position. Mark it with center punch.

5. **BORE & TAP.**



ASSEMBLING (FIG. 6, 7, 8)

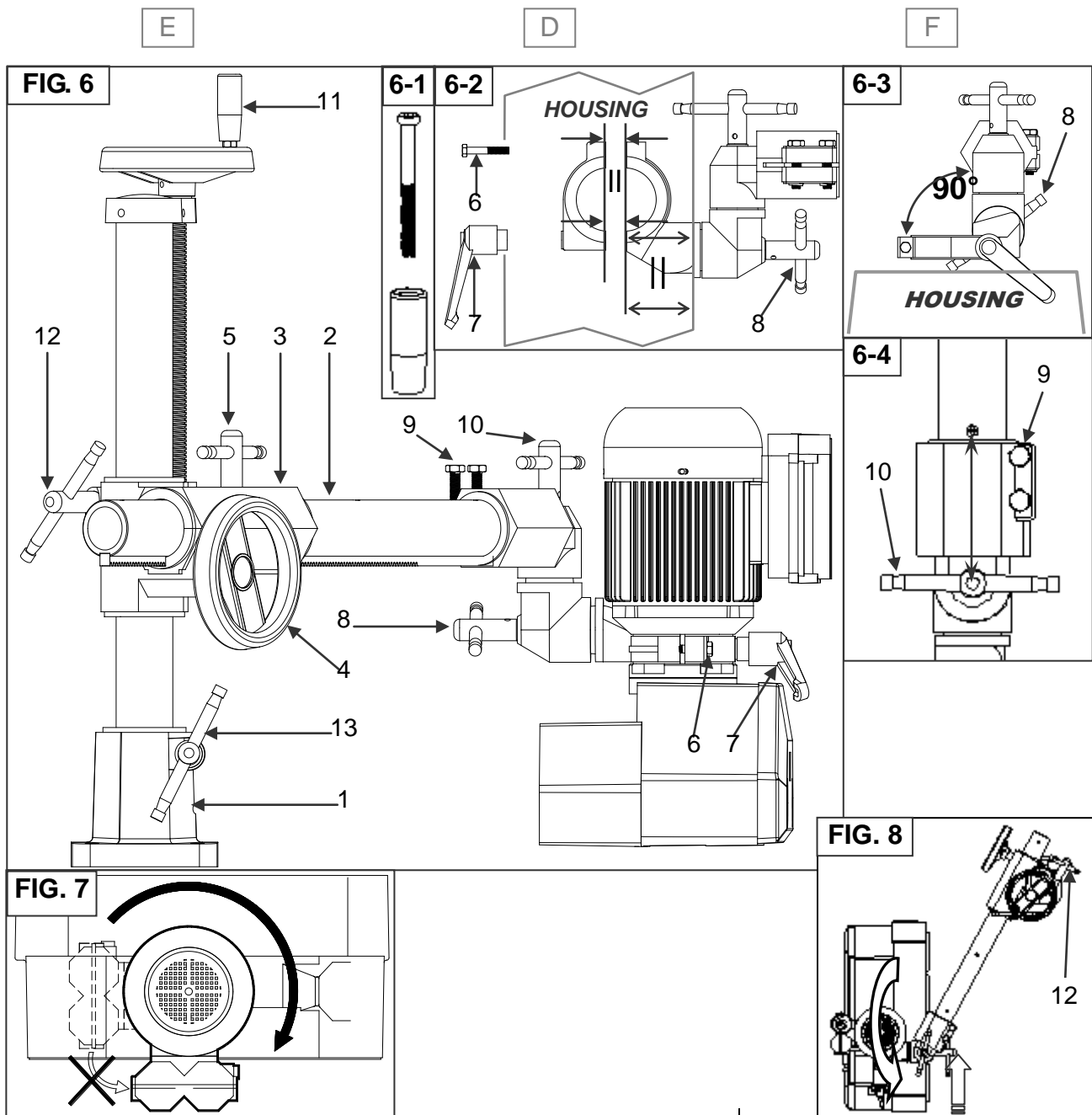
WARNING: Get help! Feeder is heavy. Do not try to do it on your own.

ZUSAMMENSETZUNG (FIG. 6, 7, 8)

WARNING: Holen Sie Hilfe! Die Zuführungsvorrichtung ist sehr schwer. Versuchen Sie nicht allein die Zuführungsvorrichtung zu installieren.

MONTAGE (FIG. 6, 7, 8)

ATTENTION: Demandez de l'aide! L'alimentateur est lourd. Ne le faites pas seul.



A) Fasten BASE (1) to table.

B) Insert "STAND" to BASE (1). Assemble HANDLE (11). (SEE 6-1).

C) Insert OVER ARM (2) into ELEVATING BRACKET (3). Turn WHEEL (4) a few turns. Tighten LEVER (5).

D) Reposition motor. Loosen 4 SCREWS. (SEE FIG 7).

E) Assemble CONTROL JOINT (6-2) onto motor neck. (SEE FIG. 6). **MAKE SURE:**

- Tighten SCREW (6) & LEVER (7) and keep gap on both side **EQUALLY SPACED**. So, once LEVER is loosen, feeder can swivel without having to loosen the SCREW (6). (SEE 6-2).
- **MOTOR CLAMP OPENING** is **PARALLEL** to **HOUSING**. (SEE 6-2).

A) Stellen Sie die BASIS (1) fest an den Tisch.

B) Stecken Sie den "STÄNDER" auf die BASIS (1). Setzen Sie den GRIFF (11) zusammen. (SIEHT FIG. 6-1).

C) Stecken Sie den Gegenhalter (2) in den ERHÖHTEN HALTER (3) hinein. Drehen das Rad (4) ein paar male. Ziehen Sie den HEBEL fest (5).

D) Neu Positionieren Sie das MOTOR. Schrauben Sie 4 SCHRAUBEN ab. (SIEHT FIG. 7).

E) Setzen die KONTROLLE-FUGE (6-2) mit dem Hals des Motors zusammen. (SIEHT FIG. 6). **SORGEN SIE DAFÜR:**

- Schrauben die SCHRAUBE (6) & den HEBEL (7) fest und halten die Distanz bei beider Seiten **IN GLEICHER ENTFERNUNG**. So daß wenn der Hebel aufgelockert ist, wird die Zuführungsvorrichtung schwingen ohne die Schrauben abschrauben zu müssen (6). (SIEHT 6-2).
- **MOTOR-KLAMMER ÖFFNUNG** steht **PARALLEL** zum **GEHÄUSE**. (SIEHT 6-2).

A) Fixez la base (1) à la table.

B) Insérez la colonne verticale dans la base (1). Assemblez la poignée (1) (VOIR FIG.6-1)

C) Insérez le bras ajustable (2) dans l'équerre d'élévation (3). Tournez la roue (4) pour quelques tours. Serrez la poignée (5).

D) Repositionnez le moteur. Desserrez 4 vis. (FIG. 7).

E) Fixez la bride de moteur (FIG. 6-2) sur le collet du moteur. (FIG. 6). **ASSUREZ-VOUS DE:**

- Resserrez les vis (6) et la poignée (7) de façon égale. Ainsi lorsque la poignée est desserrée, l'alimentateur peut pivoter sans avoir à desserrer les vis (6) (FIG. 6-2).
- La bride de moteur est parallèle au châssis. (FIG. 6-2)

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- Loosen LEVER (8) & adjust CONTROL JOINT **UPRIGHT 90°** to HOUSING. Tighten LEVER (8). (SEE 6-3).

F) Assemble FEEDER to OVER ARM (2). Tighten SCREWS (9). **MAKE SURE:**

- Center of LEVER (10) is **IN LINE** with center of OVER-ARM (2). (SEE 6-4).

G) Move FEEDER to desired position by loosen LEVER (10). Adjust height (11 & 12) and extension (4 & 5) accordingly.

H) Tighten all LEVERS.

IMPORTANT:

There is certain "PLAY" between ELEVATING KEY & BRACKET GROOVE. To assure "STURDY FEEDING," pull FEEDER against your **IN-FEED** direction, then tighten LEVER (12). (SEE FIG. 8) Do it on "EVERY ADJUSTMENT."

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- Locken den HEBEL (8) auf & stellen die KONTROLLE-FGE **SENKRECHT 90° zum GEHÄUSE**. Stellen den HEBEL fest (8). (SIEHT FIG. 6-3).

F) Setzen Sie die ZUFÜHRUNGSVORRICHTUNG zum GEGENHALTER zusammen (2). Schrauben die SCHRAUBEN (9) fest. **SORGEN SIE DAFÜR:**

- Die Mitte des HEBELS (10) bleibt **IN DER LINIE** von Mitte des GEGENHALTERS (2). (SIEHT FIG. 6-4).

G) Locken Sie den HEBEL (10) auf, damit Sie die ZUFÜHRUNGSVORRICHTUNG auf beliebige Position bewegen können. Je nach dem Bedarf stellen Sie die Höhe (11 & 12) und die Verlängerung (4 & 5) um.

H) Stellen alle HEBEL fest.

WICHTIG:

Es gibt mehrere "Spiele" zwischen den erhöhten Schlüssel und den Halterrillen. Um "FESTE ZUFUHR" sicherzustellen, ziehen Sie den ZUFÜHRUNGSVORRICHTUNG gegen die **EINFUHRSRICHTUNG**, dann ziehen Sie den HEBEL fest (12). (Sieht FIG. 8). **Wiederholen Sie diesen Schritt bei "JEDER EINSTELLUNG"**.

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- Desserrez la poignée (8), ajustez la bride de moteur perpendiculairement au châssis, serrez la poignée (8) (Voir FIG. 6-3).

F) Fixez l'alimentateur au bras ajustable (2) serrez les vis (9) **ASSUREZ-VOUS DE:**

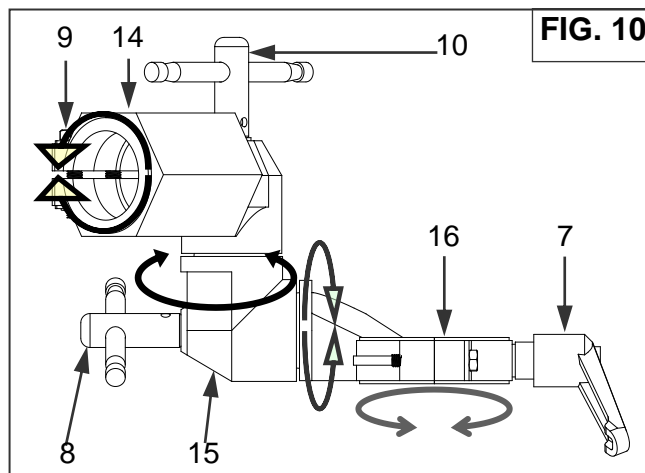
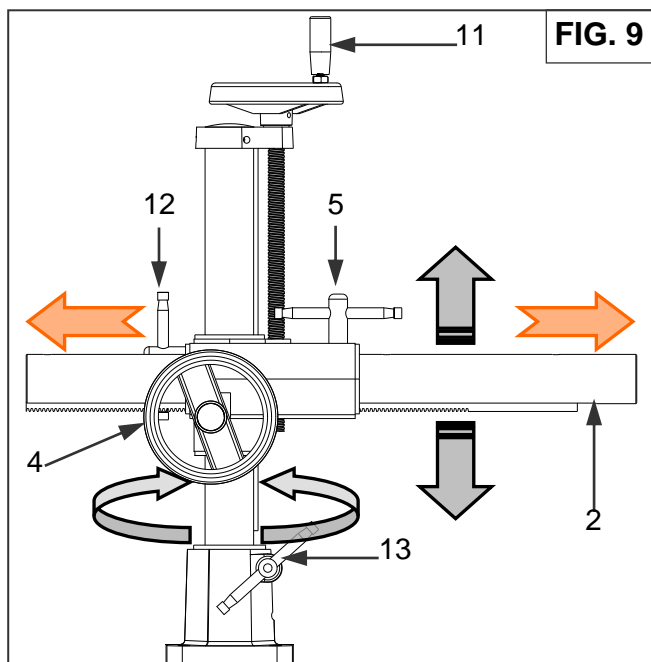
- D'aligner le centre du bras ajustable (2) avec le centre de la poignée (10) (Voir FIG. 6-4).

G) Positionnez l'alimentateur à la position désirée en desserrant la poignée (10). Ajustez la hauteur (11 et 12) et le déplacement latéral (4 et 5) selon la position choisie.

H) Serrez toutes les poignées.

IMPORTANT:

Il y a un jeu entre la clé d'élévation et la vis d'élévation. Pour assurer une alimentation ferme, tirez l'alimentateur vers la direction d'alimentation puis serrez la poignée (12). (FIG. 8) Le faire après chaque ajustement.



OPERATION **CONTROLS** **(FIG. 9 & 10)**

WARNING: Disconnect feeder from power source.

BETRIEBSKONTROLLE **(FIG. 9 & 10)**

WARNUNG: Schalten Sie den Anschluß von der Zuführvorrichtung aus.

MANŒUVRES DE **FONCTIONNEMENT** **(FIG. 9 & 10)**

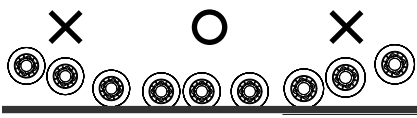
ATTENTION: Débranchez l'alimentation électrique.

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C) - 1



C) - 2

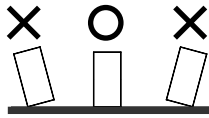
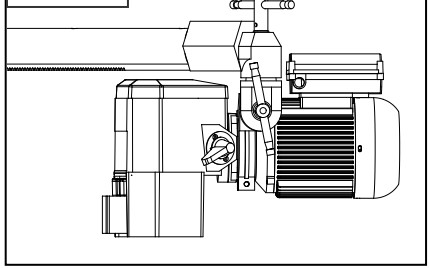


FIG. 11



A) STAND: (FIG. 9)

- OVER ARM (2) rotation. Loosen LEVER (13).
- OVER ARM (2) elevation. Loosen LEVER (12) & rotate TOP WHEEL (11).
- OVER ARM (2) extension. Loosen LEVER (5) & rotate SIDE WHEEL (4).

B) CONTROL JOINT: (FIG. 10)

- ARM BRACKET (14) Loosen SCREWS (9).
- ANGLE JOINT (15) Loosen LEVER (10).
- MOTOR CLAMP (16) Loosen LEVER (8).
- MOTOR CLAMP (16) Loosen LEVER (7).

C) ROLLER LEVELING: Lower Feeder to table. (SEE FIG. 9).

- **C)-1**: Loosen LEVER (8), Adjust ANGLE JOINT (15). (FIG. 10)
- **C)-2**: Loosen SCREWS (9), Adjust ARM BRACKET (14) (FIG. 10)
- Alignment "SLIGHTLY OFF" is acceptable. (Offset by independent suspension.)

D) SIDE FEEDING: (SEE FIG. 9, 10 & 11)

- Loosen LEVER (13), swing FEEDER off the table.
- Loosen LEVER (8), turn FEEDER 90° to floor with ROLLERS facing you. Tighten LEVER (8).
- Loosen LEVER (7), turn FEEDER 90° with SWITCH BOX facing up. Tighten LEVER (7).
- Loosen LEVER (10), push FEEDER to desired position. Tighten LEVER (10 & 13).

WARNING: Tighten all Levers after each adjustment.

A) STÄNDER: (FIG. 9)

- GEGENHALTER (2) Drehung: Locken Sie den HEBEL auf. (13).
- GEGENHALTER (2) Verlängerung: Locken Sie den HEBEL auf (12) & drehen Sie das SEITENRAD (11).
- GEGENHALTER (2) Erhöhung: Locken Sie den HEBEL auf (5) & Drehen Sie DAS OBERE RAD (4).

B) KONTROLLE-FUGE: (FIG. 10)

- ARM-HALTER (14) Schrauben die SCHRAUBEN ab (9).
- WINKEL-FUGE (15) Locken den HEBEL auf (10).
- MOTOR-KLAMMER (16) Locken den HEBEL auf (8).
- MOTOR-KLAMMER (16) Locken den HEBEL auf (7).

C) ROLLEN AUSRICHTUNG: Lassen die Zuführungsvorrichtung runter auf den Tisch, (SIEHT FIG. 9).

- **C)-1**: Locken den HEBEL auf (8), stellen WINKEL-FUGE um (15). (FIG. 10)
- **C)-2**: Schrauben die SCHRAUBEN ab (9), stellen ARM-HALTER (14). (FIG. 10)
- Ausrichtung "EIN WENIG AUF" ist akzeptabel. (Ausgleich durch eigenständige Verschiebung.)

D) SEITEZUFUHR: (SIEHT FIG. 9, 10 & 11.)

- Locken den HEBEL auf (13), schwingen die ZUFÜHRUNGSVORRICHTUNG von dem Tisch.
- Locken den HEBEL auf (8), drehen die ZUFÜHRUNGSVORRICHTUNG 90° zum Boden und die ROLLE zur Ihnen. Stellen den HEBEL fest (8).
- Locken den HEBEL auf (7), drehen die ZUFÜHRUNGSVORRICHTUNG 90° und der SCHALTERKASTEN nach Oben. Stellen den HEBEL fest (7).
- Locken den HEBEL (10), drücken die ZUFÜHRUNGSVORRICHTUNG auf beliebige Stelle. Stellen den HEBEL fest (10 & 13).

WARNUNG: Stellen alle HEBEL fest nach jeder Einstellung.

A) COLONNE DE CONTROLE: (FIG. 9)

- BRAS (2) rotation. Détachez LEVIER (13).
- BRAS (2) élévation. Détachez LEVIER (12) & tournez ROUE EN TOP (11).
- BRAS (2) extension. Détachez LEVIER (5) & tournez ROUE DE COTE (4).

B) BRIDE DE MOTEUR: (FIG. 10)

- BRAS CROCHET (14) Détachez VIS (9).
- ANGLE JOINT (15) Détachez LEVIER (10).
- PRESSEUR DU MOTEUR (16) Détachez LEVIER (8).
- PRESSEUR DU MOTEUR (16) Détachez LEVIER (7).

C) AJUSTEMENT DES ROULEAUX: Descendez l'alimentateur sur la table (VOIR FIG. 9).

- **C)-1**: Desserrez la poignée (8). Ajustez le cône pivotant (15). (VOIR FIG. 10).
- **C)-2**: Desserrez les VIS (9), Ajustez le BRAS DU CONE (14). (FIG. 10).
- Un léger jeu dans l'alignement des roues est acceptable. (Décalé par une suspension indépendante.)

D) ALIMENTATION LATÉRALE (VOIR FIG. 9, 10 et 11)

- Desserrez la poignée (13), Pivotez l'alimentateur hors de la table.
- Desserrez la poignée (8), Tournez l'alimentateur à un angle de 90° avec le sol, roulez face à vous. Resserrez la poignée (8).
- Desserrez la poignée (7), Tournez l'alimentateur de 90° avec la boîte de l'interrupteur vers le haut. Resserrez la poignée (7).
- Desserrez la poignée (10), Déplacez l'alimentateur vers la position voulue. Resserrez les poignées (10 et 13).

ATTENTION: Serrez toutes les poignées après chaque ajustement.

**POWER CONNECTION
AND GROUNDING**

(FIG. 12, 13 & 14)

WARNING: Make sure electric currency matches the motor specification (see motor cover.)

WARNING: Make sure switch is on the "OFF" position.

A) CE REQUIRED COUNTRY:

- Feeder is a supplemental tool, which works in conjunction with your shaper, table saw, jointer, ... etc. It's recommended to be used with a machine that is wired in compliance with your national or local electrical regulation.
- It must be connected to your machine through a specially designed current taps that ensures your machine's switch and emergency stop having controls of your feeder's power source. In addition, the current tap must provides an overload and under voltage protection systems.
- **Rated Current List**

Model	32	308/408	34/44/38/48/04/54/C3/MX	30/40
Current	1.5A	2A	2.5A	3A

- Electrical connection is reserved for certified electrician only.

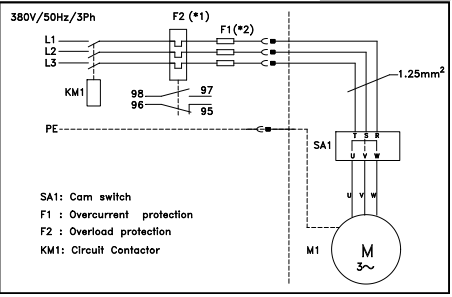
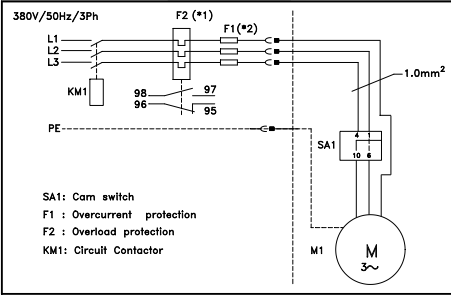
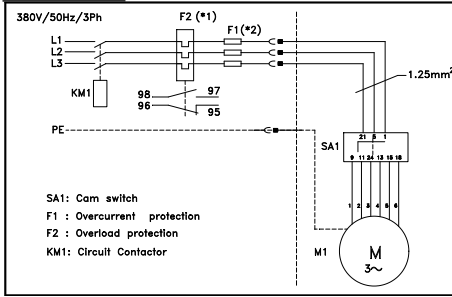
B) OTHER'S COUNTRY:

- A separate electrical outlet should be used for your feeder. The circuit should not be less than # 12. Wire properly installed and grounded in accordance with your local codes and ordinances, protected with a 15 Amp time lag fuse or circuit breaker.
- If an extension cord is used, \leq 30M (100Ft), use #12 Wire; \geq 46M (150Ft), use #10 Wire.
- Ensure all line connections make good contact. Low voltage running will damage the motor.
- Properly ground the motor to reduce the risk of electrical shock.
- The motor is equipped with a grounding conductor (green wire with or without yellow stripes.)
- If unsure, consult with a qualified electrician.

FIG

FIG

FIG



FEED RATE SETTING

VORSCHUB EINSTELLUNG

RÉGLAGE DE LA VITESSE D'ENTRAÎNEMENT

WARNING: Disconnect feeder from power source.

WARNUNG: Schalten Sie den Stromanschluß Zuführungsvorrichtung aus.

ATTENTION: Débranchez l'alimentation.

A) Choosing the right feed rate is important to achieve efficiency and quality. It is closely related to the speed of your machine, the sharpness of cutter, the hardness and the thickness of the material to be removed. Listening to the sound of your cutting tool, look (exam) closely at your sample pieces.

A) Die richtige Vorschubgeschwindigkeit zu wählen ist sehr wichtig für beste Effizienz und Qualität. Die Geschwindigkeit ihrer Maschine, die Schärfe des Schneiders und die Härte und Dicke der Materials sind eng miteinander verbunden. Hören Sie vorsichtig auf das Geräusch ihrer Schneidmaschine. Sehen Sie vorsichtig die Musterstücke nach.

A) Le bon choix de la vitesse est primordial pour réussir un travail efficace et de qualité. Le résultat est étroitement relié à la vitesse de la machine, à l'affûtage des couteaux, à la dureté du bois ainsi qu'a l'épaisseur de la pièce à travailler. Soyez attentifs au son des outils de coupe, examinez vos échantillons de travail.

(Feed rate chart below is for reference only.)

(Die Vorschubgeschwindigkeitstabelle unten ist nur als Referenz.)

(Le tableau de vitesse d'entraînement ci-dessus est donné uniquement comme référence.)

Spindle Speed	6000 R.P.M.			8000 R.P.M.			10000 R.P.M.		
Feeding speed									
Cutters									
Thickness of work piece									
6 mm	9	15	23	9	15	23	15	23	23
10 mm	8	12	15	8	15	15	12	15	15
20 mm	5	9	12	6	12	12	8	12	12
25 mm	3	5	6	5	6	8	6	8	9

B) Setting the available feed rate is a combination of MOTOR SPEEDS (FIG. 15) & GEAR SETTINGS. (Ref. FIG. 16-1, 16-2, 16-3.)

B) Die Vorschubgeschwindigkeit besteht aus Kombination der GESCHWINDIGKEIT DES MOTORS (FIG. 15) & GANG EINSTELLUNG. (Ref. FIG. 16-1, 16-2, 16-3.)

B) L'ajustement de la vitesse d'alimentation disponible se fait par des combinaisons de vitesse de moteur et de position d'engrenage. (Ref. FIG. 15, 16-1, 16-2, 16-3.)

- Model 32: (A) + GEAR SETTINGS.
- Model 308/408 (3 Phase): (B) + GEAR SETTINGS.
- Model 308/408 (1 Phase): (C) + GEAR SETTINGS.
- Model 34/44/04/54/C3: (B) + GEAR SETTINGS. FIG. 16-1.
- Model 38/48: (C) + (D) + GEAR SETTINGS. FIG. 16-2.
- Model 30/40 Variable-Speed: (C) + (E).
- Model MX: (B) + GEAR SETTINGS. FIG. 16-3.

- Model 32: (A) + GANG EINSTELLUNG.
- Model 308/408 (3 Phase): (B) + GANG EINSTELLUNG.
- Model 308/408 (1 Phase): (C) + GANG EINSTELLUNG.
- Model 34/44/04/54/C3: (B) + GANG EINSTELLUNG. FIG. 16-1.
- Model 38/48: (C) + (D) + GANG EINSTELLUNG. FIG. 16-2.
- Model 30/40 Variable-Speed: (C) + (E).
- Model MX: (B) + GANG EINSTELLUNG. FIG. 16-3.

- Modèle 32: (A) + POSITION D'ENGRENAGE.
- Modèle 308/408 (3 Phase): (B) + POSITION D'ENGRENAGE.
- Modèle 308/408 (1 Phase): (C) + POSITION D'ENGRENAGE.
- Modèle 34/44/04/54/C3: (B) + POSITION D'ENGRENAGE. FIG. 16-1.
- Modèle 38/48: (C) + (D) + POSITION D'ENGRENAGE. FIG. 16-2.
- Modèle 30/40 Variable-Speed: (C) + (E).
- Modèle MX: (B) + POSITION D'ENGRENAGE. FIG. 16-3.

E

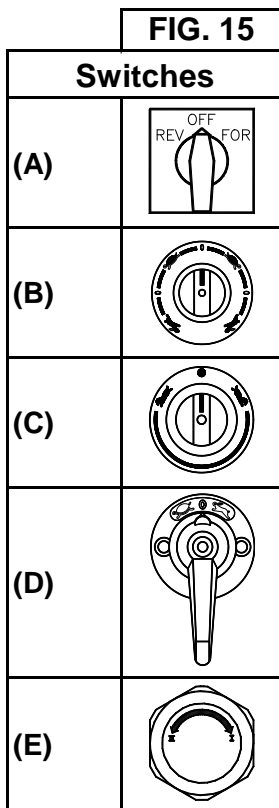
NOTE:
GEAR-SPEED-CONTROL LEVER (D) will not operate unless the motor is running position.

NOTE:
The "ACCU-RATE KNOB" (E) cannot be rotated when motor is on "OFF" position.

NOTE:
If your GEARS come with a HUB, make sure it **FACES** the SHAFT avoiding damages to the chain drive. (FIG. 17)

NOTE:
To enlarge your available speed range on feeder, extra set of gear is available at your dealer. [XG1634 for Light-duties (Model: 32 → 4 + 2 = 6) & XG2144 for Heavy-duties (Models: 34/44 → 4 + 4 = 8)]

- A) A gear arrangement and feed rate chart is attached to the **INSIDE** of GEARBOX- COVER. (Ref. FIG. 16-1, 16-2 & 16-3.)
- B) To remove GEARBOX-COVER, remove two KNOBS. (FIG. 18)
- C) To remove & rearrange GEARS, remove HEX-NUTS. (FIG. 19)



D

ANMERKUNG:
GANGE-GESCHWINDIGKEIT-KONTROLLE HEBEL (D) kommt nicht in Betrieb außer das Motor in Betrieb ist.

ANMERKUNG:
Der "ACCU-RATE KNAUF" (E) kann nicht umdrehen wenn das Motor auf "AUS" gestellt ist.

ANMERKUNG:
Wenn ihre GÄNGE mit einer NABE versehen, sorgen Sie dafür, daß die Nabe **ZU** dem SCHACHT stellen, um die Schade des Kettenantrieb zu vermeiden. (FIG. 17)

ANMERKUNG:
Um die Geschwindigkeitsumfang der Zuführungsvorrichtung zu vergrößern, können Sie ein zusätzliches Gangset beim ihrem Händler kaufen. [XG-1634 for Leichte Kapazität (Model: 32 → 4 + 2 = 6) & XG2144 für hohe Kapazität (Models: 34/44 → 4 + 4 = 8)]

- C) Eine Tabelle für Ganginstallation und Vorschubgeschwindigkeit befindet sich auf der **INNENSEITE** des GANGKASTENDECKELS. (Ref. FIG. 16-1, 16-2 & 16-3.)
- D) Wenn Sie den GANGKASTENDECKEL entfernen möchten, müssen Sie zuerst die zwei KNAUFE entfernen. (FIG. 18)
- E) Wenn Sie die GÄNGE entfernen und umstellen möchten, müssen Sie die sechseckige Schrauben entfernen. (FIG. 19)

F

NOTE:
(D) Le levier de contrôle de la vitesse d'engrenage ne fonctionne pas tant que le moteur n'est pas en fonction.

NOTE:
Le "BOUTON ACCU-VITESSE (E)" Ne peut être tourné quand le moteur est en position.

NOTE:
Si votre engrenage est muni d'un moyeu, assurez-vous qu'il soit face à l'arbre pour éviter des dommages à la chaîne motrice. (FIG. 17)

NOTE:
Pour doubler les vitesses disponibles sur votre modèle, un jeu supplémentaire de vitesse est disponible chez votre marchand. [XG1634 Jeu Light-duties (Modèle: 32 → 4+2=6) & XG2144 Jeu Heavy-duties (Modèle: 34/44 → 4+4=8)]

- C) Un tableau sur les positions d'engrenage et les vitesses d'entraînement est disponible dans le couvercle de la boîte d'engrenage. (Ref. FIG. 16-1, 16-2 & 16-3.)
- D) Pour enlever le couvercle, retirez les deux boutons. (FIG. 18)
- E) Pour retirer et ajuster les engrenages, dévissez les écrous Hex. (FIG. 19)

FIG. 16-1

Mot	Min.	Gear	Min.	Gear
L	4M(13Ft.)		10M(33Ft.)	
H	8M(26Ft.)		20M(66Ft.)	

FIG. 16-2

8 Speed Power Feeder				
	2M (6.5FT.)	6.7M (22FT.)	4M (13FT.)	13M (43FT.)
	5.5M (18FT.)	16.5M (55FT.)	11M (36FT.)	33M (108FT.)

FIG. 16-3

MX Feeding Speed		
Gear	Switch	
21 	3.5 M/Min (11.5 Ft/Min)	7 M/Min (23 Ft/Min)
25 	5 M/Min (16.5 Ft/Min)	10 M/Min (32.5 Ft/Min)
40 	12.5 M/Min (40.5 Ft/Min)	25 M/Min (81.5 Ft/Min)
44 	16 M/Min (52 Ft/Min)	32 M/Min (104 Ft/Min)

FIG. 17

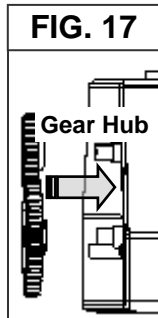


FIG. 18

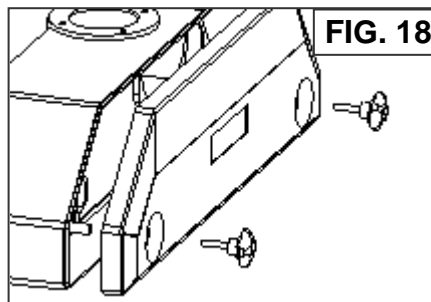
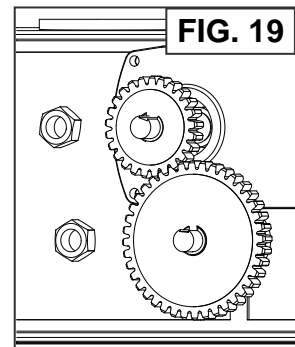


FIG. 19



ROLLER REPLACEMENT

(FIG. 20)

WARNING: Disconnect feeder from power source.

Remove SCREWS and replace ROLLER(s). **Replace** SCREWS with each roller replacement.

NOTE:
"ROTATE" roller positions periodically will prolong the usage of rollers.

ROLLER TIRE REPLACEMENT

(FIG. 21, 22 & 23)

(Heavy-duty models, 3 or 4 Rollers)

1. Remove 4 SCREWS. (FIG. 21)
2. Force ROLLER-WHEELS out. **POUND** roller on tabletop. (FIG. 22)
3. Pre-assemble FRIENDLY ROLLER with new TIRE (FIG. 23), with MALE-WHEEL (marked M) inside and FEMALE-WHEEL (marked F) outside. Lined up **UNTHREADED HOLES** of both WHEELS.
4. Slip 2 x 40mm SCREWS all the way through **UNTHREADED HOLES**. (FIG. 23)
5. Tighten new ROLLERS to housing.
6. Tighten 2 x 20mm SCREWS through remaining holes.
7. Secure all SCREWS.
8. Disregard "**SLIGHT WOBBLING**" of the new TIRES. — It will adjust itself once in use.
9. Check all SCREWS and **RE-TIGHTEN** them after first run.

ROLLE AUSWECHSELUNG

(FIG. 20)

WARNUNG: Schalten Sie den Stromanschluß von der Zuführungsvorrichtung aus.

Entfernen SCHRAUBEN und wechseln die ROLLEN. **Wechseln** SCHRAUBEN beim jeden Rolleauswechslung.

ANMERKUNG:
"DREHEN" die Positionen der Rollen regelmäßig kann die Nutzungszeit der Rollen verlängern.

ROLLERAD AUSWECHSELUNG

(FIG. 21, 22 & 23)

(Hohe Kapazität Model, 3 oder 4 Rollen)

1. Entfernen Sie 4 SCHRAUBEN. (FIG. 21)
2. Zwingen die ROLLE-RÄDE raus. **SCHLAGEN** die Rollen auf den Tisch. (FIG. 22)
3. Setzen Sie leicht die ROLLEN mit neuem RAD zusammen (FIG. 23), innen mit MÄNNLICHEM RAD (markiert M) und außen mit WEIBLICHEM RAD (markiert F). Stellen die **NICHT GEWINDELTE LÖCHER** der zwei RÄDER in einer Linie.
4. Schlüpfen 2 x 40mm SCHRAUBEN durch die **NICHT GEWINDELTE LÖCHER**. (FIG. 23)
5. Ziehen Sie die neue ROLLEN an das Gehäuse fest.
6. Schrauben 2 x 20mm SCHRAUBEN fest durch die andere Löcher.
7. Schrauben alle SCHRAUBEN fest.
8. Beachten Sie nicht die "**EIN WENIG WACKELNDE**" neuen RÄDE. — Wenn die Räder in Betrieb kommen, werden sie selbst regulieren.
9. Überprüfen Sie alle SCHRAUBEN und **SCHRAUBEN SIE NEU FEST** nach dem ersten Betrieb.

REPLACEMENT DES

ROULEAUX (FIG. 20)

ATTENTION: Débranchez l'alimentation.

Retirez les vis et remplacez le (s) rouleau (x). Remplacez les vis après chaque changement.

NOTE:
Faire une "**Rotation**" régulière prolongera la durée des rouleaux.

REPLACEMENT DES PNEUS DES ROULEAUX

(FIG. 21, 22 & 23)

(Modèles lourds, 3 ou 4 Rouleaux)

1. Enlevez les 4 VIS. (FIG. 21)
2. Retirez le rouleau, pressez légèrement le rouleau sur le dessus de la table. (FIG. 22)
3. Pré-assemblez le rouleau avec le nouveau pneu (FIG. 23), avec la roue mâle (IDENTIFIE - M) à l'intérieur et la roue femelle (IDENTIFIE - F) à l'extérieur. Alignez les trous (sans filets) des deux roues.
4. Insérez 2 vis (40mm) à travers les trous (sans filets) (FIG. 23)
5. Fixez les nouveaux rouleaux au châssis.
6. Insérez 2 vis (20mm) à travers les trous disponibles.
7. Serrez toutes les vis.
8. Ne vous préoccupez pas du léger débalancement des nouveaux pneus, l'ajustement se fera automatiquement lors de l'utilisation.
9. Contrôlez et re-serrez toutes les VIS après chaque utilisation

FIG. 21

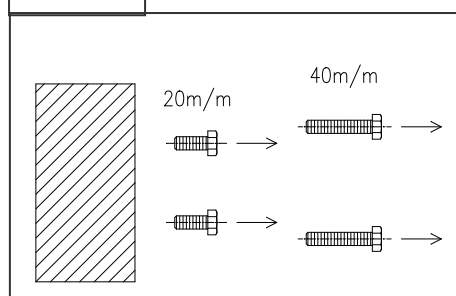


FIG. 22

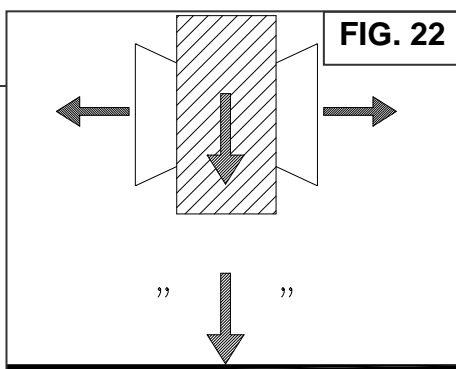
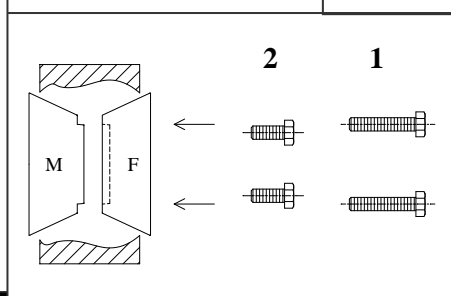


FIG. 23



LUBRICATION & MAINTENANCE

(FIG. 24 & 25)

WARNING: Disconnect feeder from power source.

A) ROLLERS:

Grease every 200 hrs (30 days) through fittings, using grease gun. Recommended Grease: # 2 GREASE. (Shell – Alvania Grease R2 or equivalents.)

B) GEARS & CHAINS:

Lubricate periodically with grease.
Recommended Grease: # 2 GREASE. (Shell – Alvania Grease R2 or equivalents.)

C) GEAR BOX:

Change oil first 200 hrs (30 days).
Change oil every 1000 hrs (6 months).
Recommended Gear Oil: MOBIL Mobilgear 630,
Shell/Omala 150 BP, Energol GR-XP 150, or equivalents.

Above recommendation is based on 8 hours/day.

D) OIL CHANGE: (SEE FIG. 6)

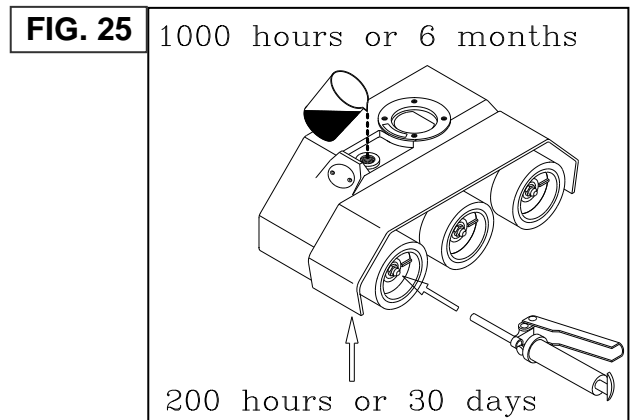
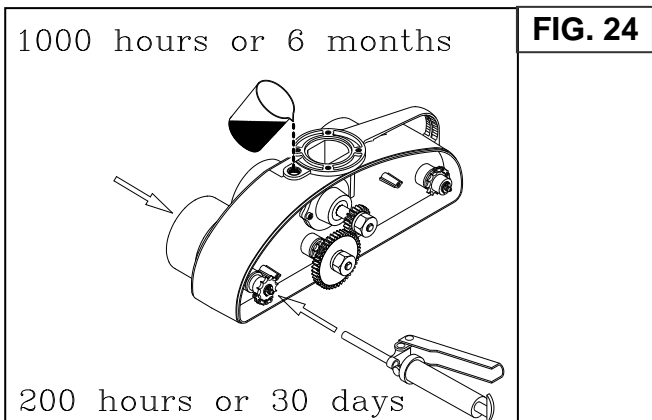
- Loosen LEVER (13) and swing FEEDER off the table.
- Loosen LEVER (8) on ANGLE-JOINT. Turn FEEDER upside down, loosen OIL-CAPE, and allow time to drain.

E) MODEL & OIL LEVEL:

32	100CC (29mm, 1-1/8")
308	130CC (42mm, 1-5/8")
408	150CC (42mm, 1-5/8")
34/44	380CC (38mm, 1-1/2")
38/48	300CC (38mm, 1-1/2")
30/40	140CC (35mm, 1-3/8")
04/54	350CC (42mm, 1-5/8")
MX	200CC (38mm, 1-1/2")

F) MAINTENANCE

Remove working-waste (saw dust, shavings, etc) from the feeder by air gun after each use.



E

D

F

E

D

F

Applications

3-Roller model shown with the 4th roller (model) in dot line.

A) ON A SHAPER: FIG. 27

- Roller Position
- VS- Cutter FIG. 27
- Feeder Position
- VS- Fence FIG. 30-1
- Feeder Pressure
- VS- Feeding Stock FIG. 31-1

B) ON A TABLE SAW: FIG. 28

- Roller Position
- VS- Saw Blade FIG. 28
- Feeder Position
- VS- Fence FIG. 30-2
- Feeder Pressure
- VS- Feeding Stock FIG. 31-1

- Roller Position
- VS- Cutter Blade FIG. 29
- Feeder Position
- VS- Fence FIG. 30-1
- Feeder Pressure
- VS- Feeding Stock FIG. 31-2

C) ON A JOINTER: FIG. 29

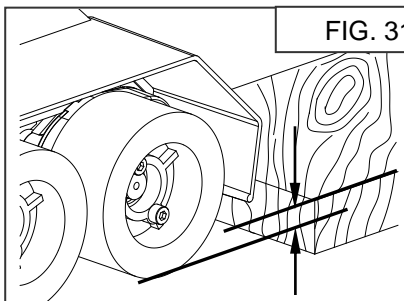
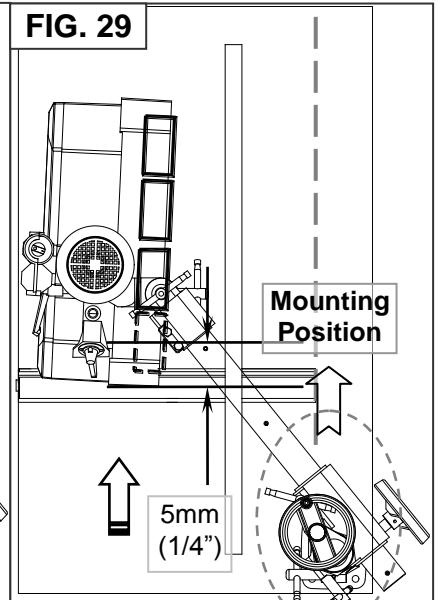
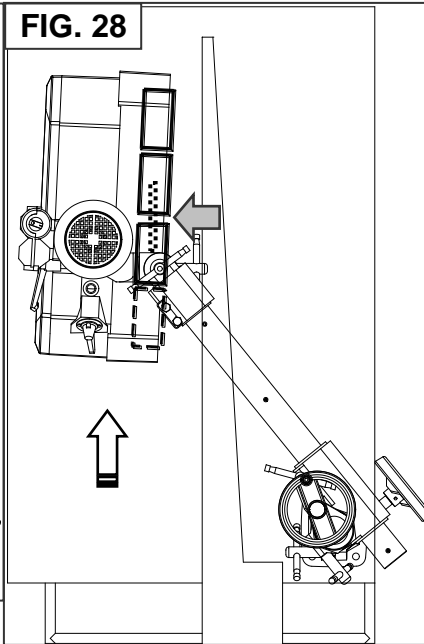
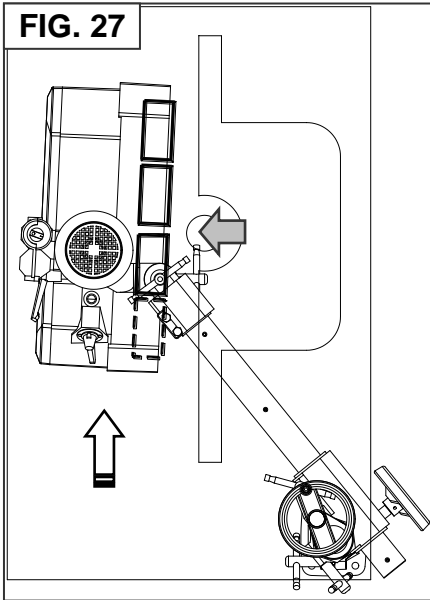


FIG. 31 31-1:
31-2:

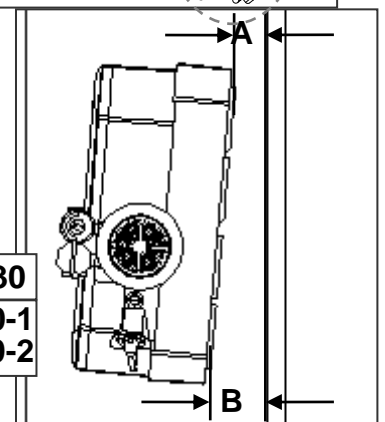


FIG. 30

B-A ≅ 5mm (1/4") : 30-1
B-A ≅ 2mm (1/16") : 30-2

E

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